

must ship June 30

# Work Order ID 70319



Page 1

Thursday, June 02, 2011 2:53:35 PM

Item ID: D4131-3 Accept

Revision ID:

Item Name: Base

Start Date: 6/2/2011 Start Qty: 4.00

Required Date: 6/17/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: CL Date: 6/10/11 Tooling:

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours |
|--------------------------------|--------------------------|----------------------|
|--------------------------------|--------------------------|----------------------|

| Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---------|--------|--------------|---------------|---------------|------------------|----------------|
|---------|--------|--------------|---------------|---------------|------------------|----------------|

|          |              |
|----------|--------------|
| Draw Nbr | Revision Nbr |
|----------|--------------|

|       |   |
|-------|---|
| D4131 | A |
|-------|---|

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-6

6

B11-6-6

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Work Order ID 70319

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Page 2

Item ID: D4131-3 Accept

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Start Date: 6/2/2011 Start Qty: 4.00

Required Date: 6/17/2011 Req'd Qty: 4.00

Reference:

Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

120 QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130 Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140 QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 110606

JB 110613

(x6)

(6)

11 06 13 (6)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Work Order ID 70319

Thursday, June 02, 2011 2:53:35 PM



Page 3

Item ID: D4131-3 Accept

Revision ID:

Item Name: Base

Start Date: 6/2/2011 Start Qty: 4.00

Required Date: 6/17/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sequence ID/ Work Center ID Operation Description Set Up/ Run Hours

150 Identify as per dwg & Stock Location: 13/ 0.00



Packaging

Memo

0.00

Packaging

160 QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

10/16/14 (6)

11/6/15

MF- 11-06-14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 02, 2011 2:53:32 PM

Page 1

Work Order ID: 70319



Parent Item: D4131-3



Parent Item Name: Base

Start Date: 6/2/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S18GA

Purchased

No

100

sf

179.4000

0.1614

0.679579

1



AB11-G-6

304/316 .050 Sheet

## Location

MAT020

112178

113062

116135

116604

116979

117653

## Loc Qty

179.4

3.4

18

20.5

1.5

69

67

## Loc Code

116135

(6)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

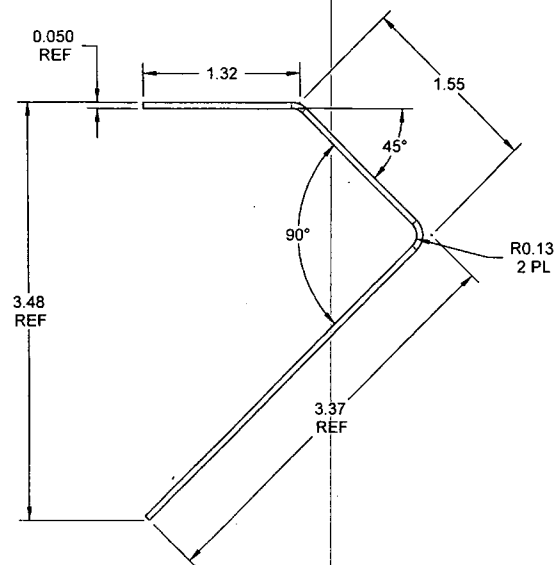
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





**D4131-3 BASE**  
MAKE FROM D4131-3F FLAT PATTERN

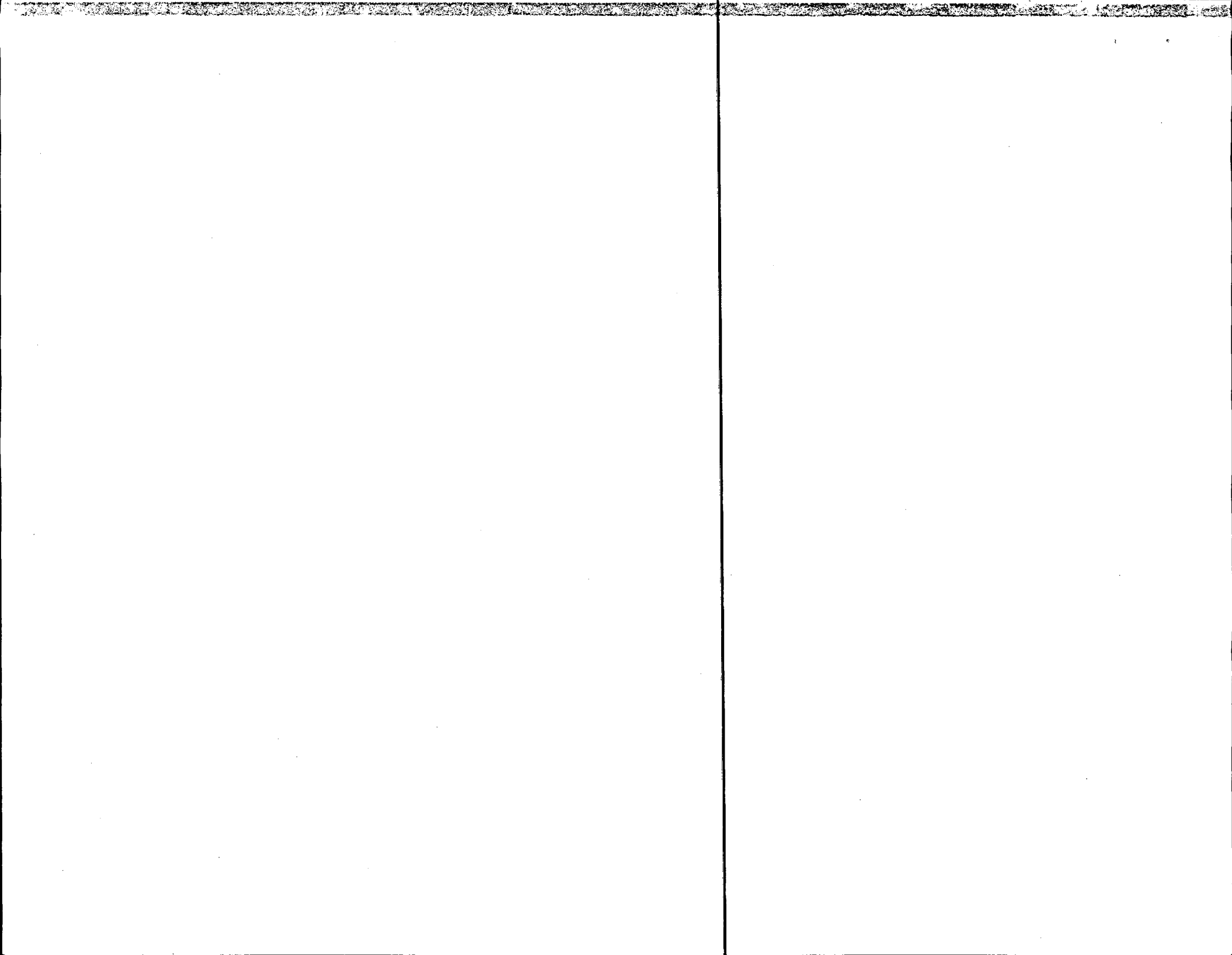
C211106/03  
W10.70319

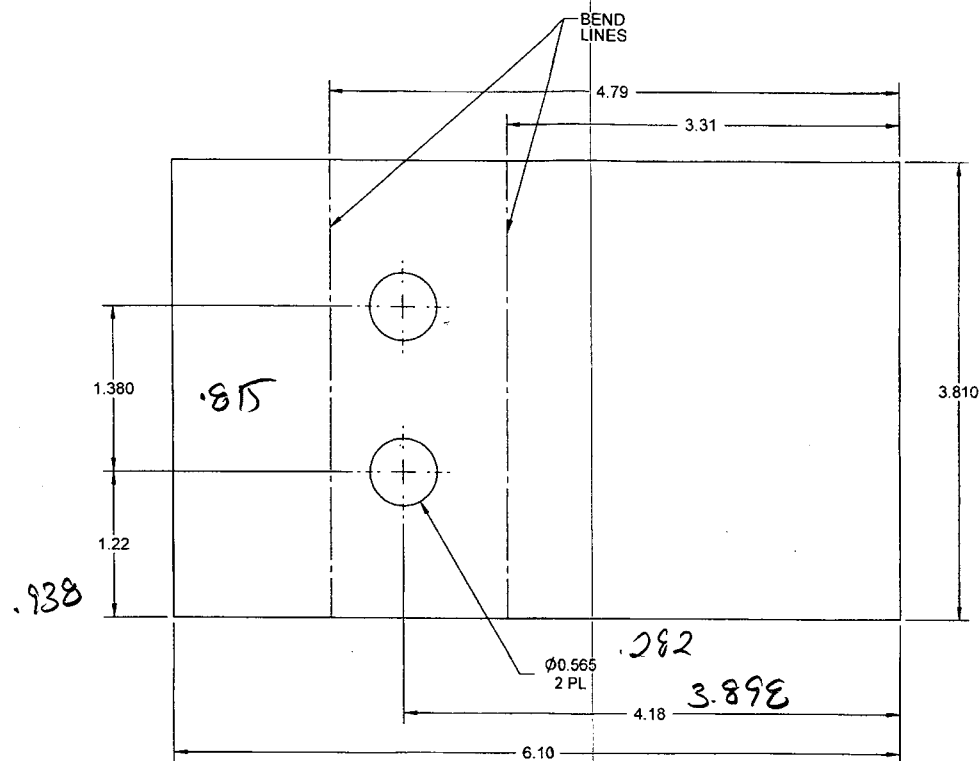
**RELEASED**  
2010-09-23  
JMT

**NOTES:**

- 1) MATERIAL: MAKE FROM D4131-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

|            |          |                                                                                                                                                                                                                                                                                                             |              |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF       | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA                                                                                                                                                                                                                                                         |              |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                                             |              |
| CHECKED    | MP       | DRAWING NO.                                                                                                                                                                                                                                                                                                 | REV. A       |
| MFG. APPR. | MP       | <b>D4131</b>                                                                                                                                                                                                                                                                                                | SHEET 5 OF 8 |
| APPROVED   | MP       | TITLE                                                                                                                                                                                                                                                                                                       | SCALE        |
| DE APPR.   | MP       | <b>MANIFOLD ASSEMBLY</b>                                                                                                                                                                                                                                                                                    | NTS          |
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**D4131-3F FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ANNEALED 2B FINISH 0.050 (18 GAUGE) SHEET  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC. M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

**RELEASED**  
2010-09-23  
ND

|            |          |                                                                                                                                                                                                                                                                                                             |              |
|------------|----------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | RF       | <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA                                                                                                                                                                                                                                                         |              |
| DRAWN      | RF       |                                                                                                                                                                                                                                                                                                             |              |
| CHECKED    | ND       | DRAWING NO.                                                                                                                                                                                                                                                                                                 | REV. A       |
| MFG. APPR. | ND       | D4131                                                                                                                                                                                                                                                                                                       | SHEET 6 OF 8 |
| APPROVED   | ND       | TITLE                                                                                                                                                                                                                                                                                                       | SCALE        |
| DE APPR.   | ND       | MANIFOLD ASSEMBLY                                                                                                                                                                                                                                                                                           | NTS          |
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